

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006525**Date Inspected:** 25-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #10 South and North Tower Shop

South Tower Lift#1:- Caltrans QA Inspector observed four grinders and a welder performed grinding and FCAW repair process on fit lugs and rat holes of diaphragm that connected skin plate A. The fit lugs and rat holes are located at elevation 18m 23m 33m and 43m diaphragm section. The grinding and FCAW welding process are removing and repair the fillet welds that have been rejected by ZPMC VT inspection. Base on Caltrans observation, no discrepancies were noted.

North tower lift#1:- Caltrans QA Inspector observed five ZPMC welders in process FCAW process on interior diaphragms of skin plate C. The interior diaphragms located at the elevation 9m to 47.6m. The minimum preheat and maximum interpass temperature requirements for FCAW process are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North tower lift#2:- Caltrans QA Inspector observed seven ZPMC welders in process FCAW process on interior diaphragms of skin plate C. The interior diaphragms located at the elevation 53m to 80.75m. The minimum preheat and maximum interpass temperature requirements for FCAW process are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations,

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

no discrepancies were noted.

Bay #11 East and West Tower Shop

West tower lift#1:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on fit lugs and interior diaphragms of skin plate C. The fit lugs and interior diaphragms located at the elevation 9m to 47.6m. The minimum preheat and maximum interpass temperature requirements for FCAW process welds are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West tower lift#2:- Caltrans QA Inspector observed six ZPMC welders in process FCAW process on interior diaphragms of skin plate C. The interior diaphragms located at the elevation 9m to 47.6m. The minimum preheat and maximum interpass temperature requirements for FCAW process welds are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|-------------------|-----------------------------|
| Inspected By: | Pau, Wai | Quality Assurance Inspector |
| Reviewed By: | Clifford, William | QA Reviewer |
